

Date: Wednesday, 2/20/2008 4:24:07 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, OUTBOARD, LH, 206
Job Number : 37549	
Estimate Number : 10818	
P.O. Number :	Part Number : D26651
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2665 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 37330	Material :
Written By :	Due Date : 3/10/2008 Qty: 4 Um: Each
Checked & Approved By : <u>08 02 21</u>	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC	
Est Rev:D As per Rev D 07-03-19 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 7075-T7351 2X6.25X7.875  
 Cut Size 2.0" x 6.25" x 7.88"  
 Grain Along Long 7.88 Length Batch no 334873 DTP 08/05/01

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Program batch number.  
 1- Inspect part number and batch number are programmed correctly.  
 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  
 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  
 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  
 5- Deburr DTP 08/05/01

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet DTP 08/05/01

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE DTP 08/05/01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 37549

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BF 08-05-02

(4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AK 08-05-

1337549  
D26651

05/05/2008

S.189 5.16

#1 324.5 F

#2 F

#3 30 mins F

#4 F

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

JS 08-05-05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-F

08/05/05

(4X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 436

JS 08/05/06

(XY)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/06 JS

Job Completion



MF 08-05-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	37549
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2665-1
<b>Inspection Dwg:</b> D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.124	0.124	0.125	0.125		
B	0.100	0.140		0.123	0.125	0.125	0.124		
C	1.125	1.145		1.134	1.1385	1.134	1.134		
D	0.615	0.685		0.645	0.648	0.645	0.645		
E	0.240	0.260		0.255	0.255	0.255	0.255		
F	1.313	1.343		1.3245	1.3245	1.3245	1.3245		
G	0.210	0.230		0.222	0.222	0.222	0.223		
H	0.100	0.180		0.160	0.160	0.160	0.160		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.572	1.572	1.573	1.572		
K	0.235	0.240					0.237		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515					0.510		
O	5.990	6.010		6.002	6.002	6.002	6.002		
P	1.245	1.255		1.250	1.247	1.249	1.249		
Q	2.495	2.505		2.499	2.498	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.500	2.500	2.499	2.499		
U	1.357	1.367		1.362	1.362	1.360	1.361		
V	0.787	0.807		0.7945	0.795	0.795	0.795		
W	0.540	0.560		0.555	0.555	0.555	0.555		
X	1.674	1.684		1.679	1.679	1.679	1.677		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.912	0.932		0.923	0.923	0.923	0.923		
AA	0.490	0.510		0.502	0.502				
AB	0.178	0.198	0.188	0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

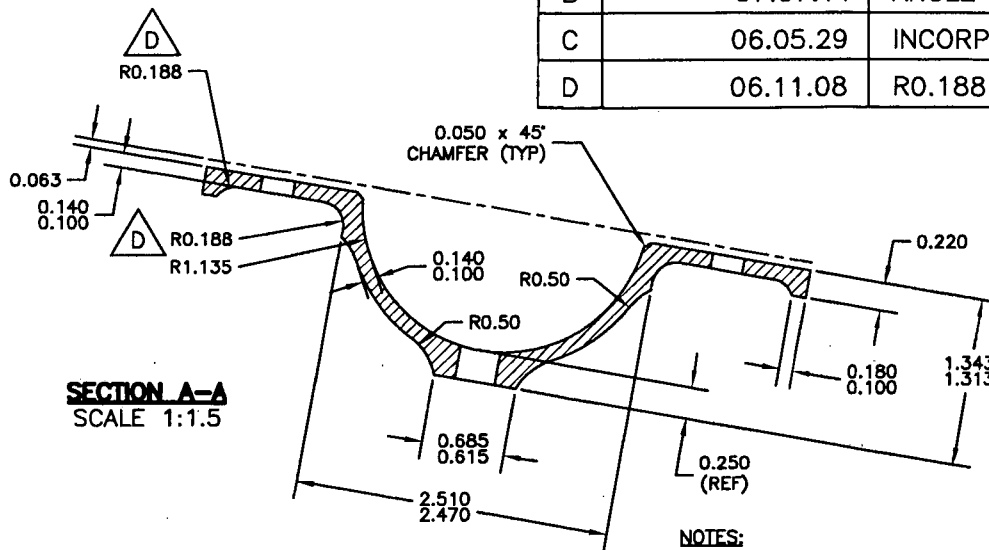
Measured by: <u>DJP</u>
Date: <u>08/05/01</u>

Audited by: <u>[Signature]</u>
Date: <u>08-05-01</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

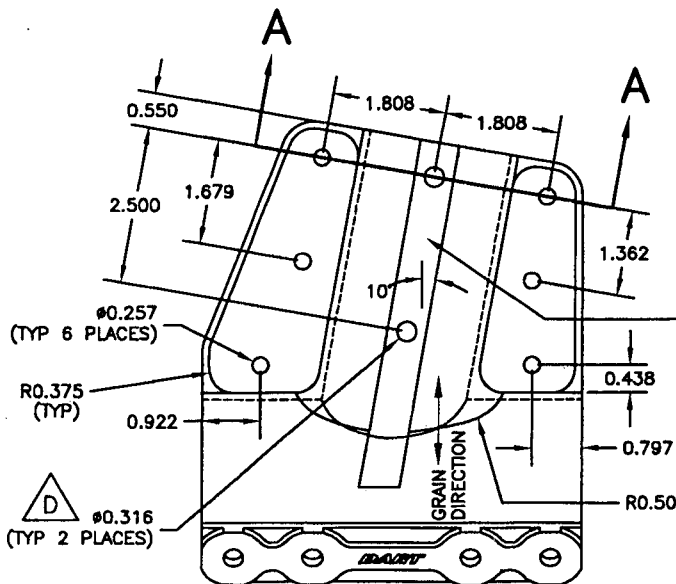


RELEASED

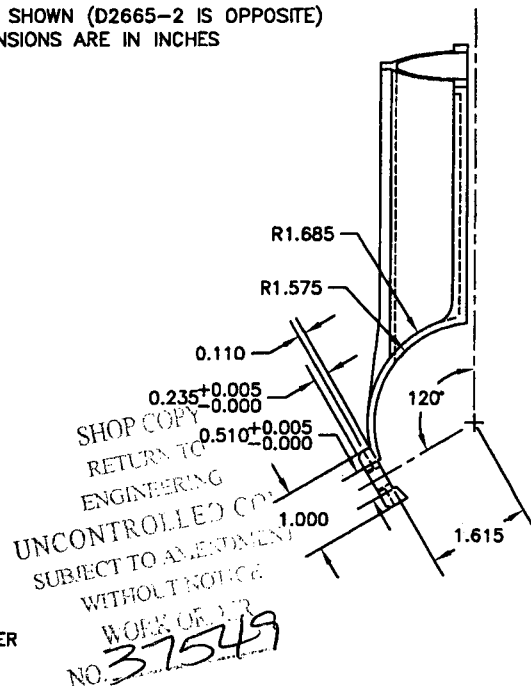
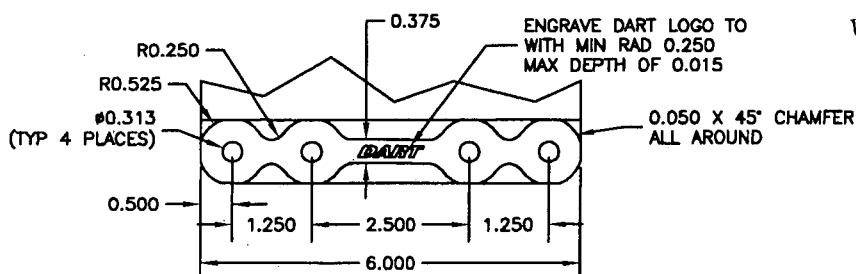
07.02.12

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010

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